

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021133**Date Inspected:** 06-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

OBG Segment12CE

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of weld joint CA6502B-051 located on Bike Path side Drain Plate. The welder is identified as 043661. ZPMC Quality Control (QC) is identified as Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the WPS B-P-2114-FCM-1. See attached photograph Pic_001.

OBG Segment12AE

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 3G position of weld joint SP3002B-01-133 located on Cross Beam side 'T' rib splice weld repair as per repair report # B-WR15245. The welder is identified as 066258. ZPMC Quality Control (QC) is identified as Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the WPS 345-SMAW-3G(3F)-Repair.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

OBG Segment12CE

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of weld joint CA6502B-052 located on Bike Path side Drain Plate. The welder is identified as 054013. ZPMC Quality Control (QC) is identified as Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the WPS B-P-2114-FCM-1.

Paint Shop 1 / OBG Segment 11DW

This QA inspector performed internal visual inspection of welds & base metal after blasting along with ZPMC and ABF Quality Assurance (QA) personnel. The member is identified as OBG Segment 11DW.

Bay 14/OBG 13CW Assy

This QA Inspector observed the following work in progress:

Sub Arc Welding (SAW) in the 1G position of weld joint SEG3015A-009 located on Counterweight side Bottom Panel (BP3070A+BP3071A) to Side Panel (SP3107A) long seam. The welder is identified as 045265. ZPMC CWI is identified as Wang Jie. The welding variables recorded by QC appeared to comply with the WPS B-T-2221-B-L2c-S-2. See attached photograph Pic_002.

Bay 16 / OBG Segment 13AE Assy

This QA inspector performed Ultrasonic Testing (UT) approximately 10% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated UT report for this date. The member is identified as 13AE plate X3718A to X3719A splice weld as per ZPMC notification # 06871 item # 1.

The weld designations reviewed are as follows:

BP3050-001-001



WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Summary of Conversations:

No relevant conversations reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Gade,Ramesh	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
